

**Work Order ID 117740**

Thursday, May 01, 2014 10:22:32 AM

**\*117740\***

Page 1

Item ID: D3140-07

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/22/2014 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: CYDate: 14/05/01

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00

**\*100\***

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

14/07/24 CY

110

QC4- 100% Inspect kits for completeness

0.00

**\*110\***

QC

Memo

0.00

Quality Control

DAS  
CS  
9-89

OCT 22 2014

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 117740**

Thursday, May 01, 2014 10:22:32 AM

**\*117740\***

Page 3

Item ID: D3140-07

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/22/2014 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: CA

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

14-10-22

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

14/10/2314-10-22

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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# Picklist Print

Thursday, May 01, 2014 10:22:31 AM

Page 1

Work Order ID: 117740

\*117740\*

Parent Item: D3140-07

\*D3140-07\*

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 12/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3140-09 *D3140-09* Doubler Assembly		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST156	536334	4							
					53767	4							
D3140-91 *D3140-91* Doubler		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		3							
					52203	3							
D3140-99 *D3140-99* Doubler		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		3							
					36761	1							
					52632	2							
D3140-101 *D3140-101* Doubler		Manufactured	No			100	Each	3.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST027		3							
					78724	3							

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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### FAULT CATEGORY

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# Picklist Print

Thursday, May 01, 2014 10:22:31 AM

Work Order ID: 117740

**\*117740\***

Parent Item: D3140-07

**\*D3140-07\***

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 12/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3140-103

Manufactured No

100

Each

2.0000

1

1

**\*D3140-103\***

Doubler

**\*\***

*02/14/06/17*

Location

Loc Qty

Loc Code

CA

2

34377

2

1

D3140-105

Manufactured No

100

Each

4.0000

1

1

**\*D3140-105\***

Doubler

**\*\***

*02/14/06/17*

Location

Loc Qty

Loc Code

ST028

4

78721

4

1

D3140-301

Manufactured No

100

Each

8.0000

1

1

**\*D3140-301\***

Doubler

**\*\***

*02/14/06/17*

Location

Loc Qty

Loc Code

CA

8

78717

8

1

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

# PURCHASE ORDER

Purchase Order ID PO24037

Purchase Order Date 5/1/2014

PO Print Date 9/10/2014

Page Number 3 of 6

**Order From :**

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 10100  
  
GRAND-MERE, QC G9T 5K7  
CA

VU-DEL003

**Ship To :** DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 819 533 5788

**Ship To Contact**

**Ship To Phone**

**Ship Via:** FedEx PI collect

**Ship Acct:**

**Buyer**

Michael Gregoire

**Customer POID**

**Customer Tax #**

10127-2607

**Terms**

Net 30

**Currency**

USD

**FOB**

EXW - (Ex Works)

✓ 6	D3140-06P	Door	9/10/2014	1.00	✓	\$8,842.92	\$8,842.9
			Yes	Each			
			9/10/2014				

Manufacture as oer Drawing D3140 rev.F

**Line Total:** \$8,842.9

7	D3140-07P	Door	9/10/2014	1.00	✓	\$8,842.92	\$8,842.9
			Yes	Each			
			9/10/2014				

Manufacture as oer Drawing D3140 rev.F

**Line Total:** \$8,842.9

✓ 8	D3140-08P	Door	9/10/2014	1.00	✓	\$8,842.92	\$8,842.9
			Yes	Each			
			9/10/2014				

Manufacture as oer Drawing D3140 rev.F

**Line Total:** \$8,842.9

**PO Instructions:** Fedex Acc# 151793240

**Note:**

9/10/2014

Mastering Innovation

**DELASTEK**

DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

13065  
**PACKING SLIP****CERTIFICATE OF COMPLIANCE**

Invoice No:	58543
Customer No:	DART US

**Bill To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

**Ship To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
16-10-2014	01-05-2014	24599	Michael Gregoire	PO24037 REV 1	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Freight LTL Collect	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O Qty	Current Ship	Item number	Description	
1	0	1	DKC135-0017	Line #5 D3140-05 Door Left Non Assy (Grosse) U of M: Cha DWG D3140 REV. F Serial # Lot # 62922 62922	
1	0	1	DKC135-0019	Line #6 D3140-06 Door Right Non Assy (Grosse) U of M: Cha DWG D3140 REV. F Serial # Lot # 62923 62923	
1	0	1	DKC135-0018	Line #7 D3140-07 Door Left Non Assy (Petite) U of M: Cha DWG D3140 REV. F Serial # Lot # 62922 62922	
1	0	1	DKC135-0020	Line #8 D3140-08 Door Right Non Assy (Petite) U of M: Cha DWG D3140 REV. F Serial # Lot # 62923 62923	

**DOCUMENT INCLUS**

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-35

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Mastering Innovation

**DELASTEK**

DELASTEK Inc.  
2699 Se Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

130165

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice No.	58543
Customer No.	DART US

**Bill To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

**Ship To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
16-10-2014	01-05-2014	24599	Michael Gregoire	PO24037 REV 1	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Freight LTL Collect	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship	Item number	Description	
1	0	1	DKC135-0017	Line #5 D3140-05 Door Left Non Assy (Grosse) U of M: Cha DWG D3140 REV. F Serial # Lot # 62922 62922	
1	0	1	DKC135-0019	Line #6 D3140-06 Door Right Non Assy (Grosse) U of M: Cha DWG D3140 REV. F Serial # Lot # 62923 62923	
1	0	1	DKC135-0018	Line #7 D3140-07 Door Left Non Assy (Petite) U of M: Cha DWG D3140 REV. F Serial # Lot # 62922 62922	
1	0	1	DKC135-0020	Line #8 D3140-08 Door Right Non Assy (Petite) U of M: Cha DWG D3140 REV. F Serial # Lot # 62923 62923	

DOCUMENT INCLUS



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Accepted by:

Quality department

AQ-35

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Mastering Innovation

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2699 Se Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

130-15-E

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice No.	58543
Customer No.	DART US

**Bill To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

**Ship To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
16-10-2014	01-05-2014	24599	Michael Gregoire	PO24037 REV 1	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
Fedex Freight LTL Collect		Point de départ		Melody Shapcott, ext. 235	
Order Qty	B.O. Qty	Current Ship	Item number	Description	
1	0	1	DKC135-0017	✓ Line #5 D3140-05 Door Left Non Assy (Grosse) U of M: Cha DWG D3140 REV. F Serial # Lot # 62922 62922	
1	0	1	DKC135-0019	✓ Line #6 D3140-06 Door Right Non Assy (Grosse) U of M: Cha DWG D3140 REV. F Serial # Lot # 62923 62923	
1	0	1	DKC135-0018	✓ Line #7 D3140-07 Door Left Non Assy (Petite) U of M: Cha DWG D3140 REV. F Serial # Lot # 62922 62922	
1	0	1	DKC135-0020	✓ Line #8 D3140-08 Door Right Non Assy (Petite) U of M: Cha DWG D3140 REV. F Serial # Lot # 62923 62923	

DOCUMENT INCLUS



It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

*Matthew Hyslop*  
Quality department



AQ-35

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2014-07-01 12:27:40  
 Utilisateur: marc dubé

## Feuille de Procédé

8/10 Août

 Client : DART US DART AEROSPACE  
 Numéro Job : 62922  
 Numéro : 3406  
 Numéro B.A. :  
 Cette fois : 2014-07-01 No. :  
 Prsht Rev. : NC  
 Prem. fois : - - Type :  
 Job précédente : 61667

 Nom Dessin : DOOR KIT  
 Numéro Article : DKC135-0017/-0018  
 Numéro Dessin : D3140  
 Projet Numéro : DK-359  
 Révision dessin : F  
 Matériel : Fibercote E-761  
 Date Dûe : 2014-09-15  
 13/oct

Qté: 1 Ud UNITE

 Écrit par :  
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce Client: D3140-05/-07

 Process Sheet Rév.: 03 remplacer AAC0559 et  
 AAC0563 par AAC2032 et AAC1361 respectivement,  
 changé AC0883 et AC0884 par AAC1885 et AAC1887  
 respectivement à 2 endroits qui avait été oubliés

COPIE

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Description :

1.0 OUTILLAGE Outillage nécessaire pour la job



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

 Moule N° B30-23000-01T  
 Patron de découpe N° B30-23000-57T  
 Patron de découpe N° B30-23000-61T  
 Patron de découpe N° B30-23000-63T  
 Patron de découpe N° B30-23000-71T  
 Patron de découpe N° B30-23000-73T  
 Patron de découpe N° B30-23000-75T  
 Patron de découpe N° B30-23000-77T  
 Patron de découpe N° B30-23000-79T  
 Gabarit de taillage N° B30-23000-05T ( 2 pièce ) et N° B30-2300-03T  
 Forme de silicone N° B30-23000-07T

2.0 AAC0854 Frekote #700-NC

 Comment Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)  
 Frekote #700-NC N° de Lot: 1-44859-1

3.0 PRÉPARATION Préparation du moule



Comment Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

Faire la préparation du moule selon IF135-0001 et 135-0009













DATE: 28-08-14 SCAU: 75



Date: Mardi, 2014-07-01 12:27:40

Utilisateur: marc dubé

### Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 62922		Numéro DKC135-0017/-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
4.0	AMB0211	Epoxy prepreg E-761 style 7781	
Comment	Qty.: 12.30 VERGE(s)/Unit Total: 12.30 VERGE(s) Epoxy prepreg E-761 style 7781 N° de Lot: <u>4575710AA</u>		
5.0	DECOUPE	Découpe manuelle des pièces	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi* (7 Paquet = 24.5 verges)  Quantité: <u>1</u> Date: <u>28-08-14</u> Sceau: 		
6.0	DRAPAGE	Drapage	
			
Comment	Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs  Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0001  Quantité: <u>1</u> Date: <u>03-08-14</u> Sceau:  		
7.0	<del>AAC1885</del> <u>AAC1952</u>	Tissu à délaminer Release ply B	
Comment	Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s) Tissu à délaminer Release ply B # de Lot: <u>1-43617-2</u>		
8.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment	Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: <u>1-45581-1</u>		
9.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment	Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)		
10.0	AC0882	Sac à vide N° Strechlon 700	
Comment	Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)		
11.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)		
12.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs  Faire le bagging sur la pièce selon IF135-0001 et IG 001  Quantité: <u>1</u> Date: <u>03-08-14</u> Sceau:  		

Date: Mardi, 2014-07-01 12:27:40

Utilisateur: marc dubé

## Feuille de Procédé

Cliant: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 62922

Numéro DKC135-0017/-0018

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

13.0

CUISSON

Cuisson de pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0001, IG 0012 et PTN #20 N° de

Cuisson: 8764

Quantité: 1 Date: 3-9-14 Sceau:



14.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Retirer le montage cuisson et faire les retouches de la pièces afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1 Date: 4/09/14 Sceau:



15.0

INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1 Date: 4sept14 Sceau:



16.0

AAC1618

Rohacell 71S 1"thick 49.2" x 98.4" plain

Comment Qty.: 2.000 FEUILLE(s)/Unit Total : 2.000 FEUILLE(s)

Rohacell 71S 1"thick 49.2" x 98.4" plain

N° de Lot: 1-45735-1

17.0

DECOUPE

Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs





Faire la découpe des pièce de mousse structurales (Rohacell) sur la scie à ruban selon IF135-0001.

Quantité: 1 Date: 10/09/14 Sceau:



Date: Mardi, 2014-07-01 12:27:40  
Utilisateur: marc dubé

### Feuille de Procédé






Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 62922		Numéro DKC135-0017-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
18.0	SÉCHAGE/ ANEAL	Séchage / Anealing	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le séchage du Rophacell selon IF135-0001 et les information du manufacturier. N° de Cuisson: <u>87771</u>			
Quantité: <u>1</u> Date: <u>4/09/14</u> Sceau: 			
19.0	AMB0442	Film adhesif EA9696 36" large x 0.06(psf)	
Comment Qty.: 6.12 VERGE CAR(s)/Unit Total : 6.12 VERGE CAR(s) Film adhesif de EA9696 36" large x 0.06 (psf) #LOT: <u>4723610AA</u>			
20.0	AAC2032	Core splice adhesive NB-51/301	
Comment Qty.: 5.0 PIED CARRE(s)/Unit Total : 5.0 PIED CARRE(s) Core splice adhesive NB-51/301 N° de Lot: <u>1-45752-1</u>			
21.0	AAC1361	Putty AD Tech P-17	
Comment Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s) Putty AD Tech P-17 N° de Lot: <u>1-45756-1</u>			
22.0	AAC1630	N° D3140-09, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-09, Doubler N° de Lot: <u>4743780AA</u>			
23.0	AAC1631	N° D3140-87, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-87, Doubler N° de Lot: <u>4743710AA</u>			
24.0	AAC1632	N° D3140-91, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-91, Doubler N° de Lot: <u>4743790AA</u>			
25.0	AAC1634	N° D3140-95, Doubler	
Comment Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s) N° D3140-95, Doubler N° de Lot: <u>4743720AA</u>			
26.0	AAC1635	N° D3140-97, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-97, Doubler N° de Lot: <u>4743730AA</u>			
27.0	AAC1637	N° D3140-99, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-99, Doubler N° de Lot: <u>47437100AA</u>			
28.0	AAC1638	N° D3140-101, Doubler	
Comment Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s) N° D3140-101, Doubler N° de Lot: <u>47437110AA</u>			



Date: Mardi, 2014-07-01 12:27:40

Utilisateur: marc dubé




















### Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 62922		Numéro DKC135-0017-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
29.0	AAC1639	N° D3140-103, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)	N° D3140-103, Doubler N° de Lot: 47437126AA	
30.0	AAC1641	N° D3140-105, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)	N° D3140-105, Doubler N° de Lot: 47437130AA	
31.0	AAC1643	N° D3140-241, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)	N° D3140-241, Doubler N° de Lot: 4743740AA	
32.0	AAC1644	N° D3140-301, Doubler	
Comment	Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)	N° D3140-301, Doubler N° de Lot: 4743750AA	
33.0	NETTOYAGE	Nettoyage des pièces	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
Faire le nettoyage des doublers selon IG 0063			
Quantité:	1	Date: 10/09/14	Sceau: 56 73
34.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Mise en place des doublers et des pièces de mousse structurales selon IF135-0001			
Quantité:	1	Date: 15-09-14	Sceau: 71 40
35.0	AAC1885	Tissu à délaminer Release ply B	
Comment	Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)		
36.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment	Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)		
37.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment	Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)		
38.0	AC0882	Sac à vide N° Stretchlon 700	
Comment	Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)		
39.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)		

Date: Mardi, 2014-07-01 12:27:40















Utilisateur: marc dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> DOOR KIT	
<b>Numéro Job:</b> 62922	<b>Numéro</b> DKC135-0017-0018	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
40.0	BAGGING	Faire le bagging sur la pièce
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs		
Faire le montage cuisson selon IF135-0001 et IG 0012		
Quantité: <u>1</u> Date: <u>15-09-14</u> Sceau:  		
41.0	CUISSON	Cuisson de pièce
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs		
Faire la cuisson de la pièces selon IF135-0001, IG 0012, et PTN #20 N° de Cuisson: <u>8801</u>		
Quantité: <u>1</u> Date: <u>15-09-14</u> Sceau: 		
42.0	DÉMOULAGE	Démoulage de la pièce
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs		
Retirer le montage cuisson de sur la pièce et enlever les résidu de ruban adhésif en teflon et les barre d'aluminium, garder seulement la barre qui sépare les deux pièces		
Quantité: <u>1</u> Date: <u>16/09/14</u> Sceau:  		
43.0	DECOUPE	Découpe manuelle des pièces
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs		
Usinage des mousse structurales selon IF135-0001 et installer les doublers		
Quantité: <u>1</u> Date: <u>22/09/14</u> Sceau:  		
44.0	INSPECTION	Inspection générale
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs		
Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étapes.		
Quantité: <u>1</u> Date: <u>22/09/14</u> Sceau: 		














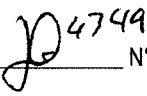
Date: Mardi, 2014-07-01 12:27:40  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 62922		Numéro DKC135-0017-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
45.0	AMB0211	Epoxy prepreg E-761 style 7781	
Comment Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s) Epoxy prepreg E-761 style 7781 N° de Lot: 4575720AA			
46.0	DRAPAGE	Drapage	
 			
Comment Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs Drapage de la coquille intérieur selon IF135-0001 Quantité: 1 Date: 23-09-14 Sceau:   			
47.0	AAC1885	Tissu à délaminer Release ply B	
Comment Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)			
48.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)			
49.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)			
50.0	AC0882	Sac à vide N° Strechlon 700	
Comment Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)			
51.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)			
52.0	BAGGING	Faire le bagging sur la pièce	
 			
Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs Faire le montage cuisson selon IF135-0001 et IG 0012 Quantité: 1 Date: 23-09-14 Sceau:   			
53.0	CUISSON	Cuisson de pièce	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs Faire la cuisson de la pièces selon IF135-0001, IG 0012, et PTN #20 N° de Cuisson: 8821 Quantité: 1 Date: 23-09-14 Sceau: 			

Date: Mardi, 2014-07-01 12:27:40  
Utilisateur: marc dubé













## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	DOOR KIT
Numéro Job:	62922	Numéro	DKC135-0017/-0018
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
54.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs		
	Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer		
	Retirer la pièce du moule		
	Quantité: 1	Date: 25-09-14	Sceau:  
55.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs		
	Faire le trimage de finition de la pièce selon IF135-0003		
	Quantité: 1	Date: 24-09-14	Sceau: 
56.0	INSPECTION	Inspection générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel"		
	Quantité: 1	Date: 01/10/14	Sceau: 
57.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: 476845011A		
58.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 476841011A		
59.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs		
	Faire l'application du primer selon IG 0008.		
	Quantité: 1	Date: 30-09-14	Sceau:  4749 N° Fiche mélange: _____

Date: Mardi, 2014-07-01 12:27:40

Utilisateur: marc dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> DOOR KIT	
<b>Numéro Job:</b> 62922	<b>Numéro</b> DKC135-0017/-0018	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
60.0	SABLAGE	Sablage
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs		
Faire le sablage du primer selon IF135-0003		
Quantité: <u>1</u> Date: <u>11/10/14</u> Sceau:  		
61.0	PRIMER	Application primer
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs		
Faire l'application du primer selon IG 0008.		
Quantité: <u>1</u> Date: <u>31-09-14</u> Sceau: <u>20</u> N° Fiche		
mélange: <u>10521</u>		
62.0	IDENTIFICATION	Identification des pièces
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs		
Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanisme de porte selon IG 0055.		
N° de pièce Grosse porte: D3140-05		
N° de pièce Petite porte: D3140-07		
N° de Job ( sur les 2 pièces): <u>62922</u>		
Date de fabrication (sur les 2 pièces): <u>14-10-14</u>		
Sceau d'inspection.		
Quantité: <u>1</u> Date: <u>14-10-14</u> Sceau: <u>4451</u>		
63.0	INSPEC FINAL	Inspection finale
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.		
Quantité: <u>1</u> Date: <u>16-10-14</u> Sceau: 		

Date: Mardi, 2014-07-01 12:27:40  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 62922

Nom Dessin: DOOR KIT  
Numéro DKC135-0017/-0018

Numéro Job:



# Séq.:

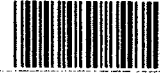
Machine ou Opération:

Description :

64.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057

Quantité: 1 Date: 16-10-14 Sceau: 4436 N.m